

SP-15 Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STABILIZER ARM

Job Number : 41014 -2

(3)

Item Number : 13523

Part Number : PB674300157

Lot Number : 06/08/2008 S.O. No. :

Drawing Number : B6743001 P.13

Issue : NC

Project Number : N/A

Next Issue : 11

Type : SMALL /MED FAB

Drawing Revision : B1

Previous Run :

Material :

Due Date : 13/08/2008

Qty: 8 Um: Each

Issued By :

Checked & Approved By :

Est Rev:A 08-07-25 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 PB6743001111

Tube End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube End Plate

batch: B40013 ✓

Tube Arm

2.0 PB6743001107



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube Arm

batch: 41011 ✓

3.0 LARGE FAB 1



Comment: LARGE FABRICATION RESOURCE 1
1-Weld assembly as per dwg PB67-43001

INSPECT WORK TO CURRENT STEP

4.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

VISUAL WELDING INSPECTION

5.0 QC9



Comment: VISUAL WELDING INSPECTION

Male Eye

6.0 PB6743001109



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Male Eye

batch: B40011

FF 08/08-08

Form: rprocess

Date: Wednesday, 06/08/2008 10:52:38 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STABILIZER ARM

Job Number: 41014

Part Number: PB674300157

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

SPRING SLOTTED PIN

batch: 17850



att. mf 08-08-26 FF 07-08-08 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -107 and -109 using existing pilot hole of -107 as per dwg
2- install spring pin

FF 08-08-08 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/08 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 9:15

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:45

mf 08/08/08 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/08/08 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

39952



13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

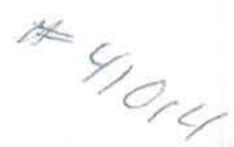


08/08/27

Job Completion



mf 08-08-26



Date: Tuesday, 26/08/2008 2:29:14 PM
 User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 41014	Customer	: Dart Helicopters Services
Estimate Number	: 13523	DWG Name	: STABILIZER ARM
Purchase Order #	:	Part Number	: PB674300157
Complete Date	: / / : : AM	DWG Number	: B6743001 P.13
		Rev.	: B1

DUE DATE	ORDERED	DELIVERED
13/08/2008	5	3

1.0 PB6743001111-Tube End Plate	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
07/08/2008	PLOU01: Plouffe, Sonia	PB6743001111	8.000	\$11.07	Lot # 40013 Qty. 8
Subtotal:	QTD:	0	CTD:	8	\$11.07

2.0 PB6743001107-Tube Arm	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
07/08/2008	PLOU01: Plouffe, Sonia	PB6743001107	8.000	\$319.67	Lot # 41011 Qty. 8
Subtotal:	QTD:	0	CTD:	8	\$319.67

3.0 LARGE FAB 1	Internal Operation						
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
07/08/2008	PLOU01: Plouffe, Sonia	Run	8.000	2.23	\$40.85	2.23	68.63
Subtotal:	QTD:	8	CTD:	0	2.23	\$109.48	

6.0 PB6743001109-Male Eye	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
07/08/2008	FRAN01: Franken, Frans	PB6743001109	5.000	\$385.32	Lot # 40011 Qty. 5
Subtotal:	QTD:	0	CTD:	5	\$385.32

7.0 240107-SPRING SLOTTED PIN	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
07/08/2008	FRAN01: Franken, Frans	240107	10.000	\$1.20	Lot # 17850 Qty. 10
Subtotal:	QTD:	0	CTD:	10	\$1.20

8.0 SMALL FAB 1	Internal Operation						
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
07/08/2008	FRAN01: Franken, Frans	Run	5.000	2.34	\$39.43	2.34	95.81
Subtotal:	QTD:	5	CTD:	0	2.34	\$135.24	

10.0 POWDER COATING	Internal Operation						
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
08/08/2008	GREG01: Gregory, Marc	Run	5.000	0.75	\$11.66	1.50	56.69
Subtotal:	QTD:	5	CTD:	0	0.75	\$68.35	

		TIME	COST
	Machine Time:	6.07	\$221.13
	Labor:	5.32	\$91.94
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$717.26
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$1030.33

COST PER UNIT:	\$343.44
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